

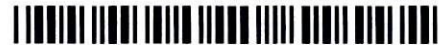


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005299

D119-646-314
Job Sheet 182344



Part No: D119-646-314

Job Qty: 3 ea

Part Name: Skidtube Protector, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A 15.12.10 NEW ISSUE DD VERF:JLM IPP REV:B 17.05.10 AS PER DSI9734 REV B
DD VERF:JFS IPP REV:C 17.08.16 AS PER DSI9734 REV C DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Stores/Pkg-1	8-6 9	SEP 04 2018 Sign-off
110	Packaging	3 pcs	9/7/18	9/7/18	0.00	0.00	Packaging1-1	8-6 9	SEP 24 2018
120	QC	3 pcs	9/7/18	9/7/18	0.00	0.00	QC4	8-6 9	SEP 24 2018
130	Packaging	3 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1	8-6 9	SEP 24 2018
135	DC	3 pcs	9/7/18	9/7/18	0.00	0.00	DC	8-6 9	SEP 24 2018
140	QC21-FG	3 Ea	9/7/18	9/7/18	0.00	0.00	QC21	8-6 9	SEP 24 2018

Part Op 130 - Identify and pack for shipping as per PPP D119-646-314 Location:
Descriptions: 135 - Photocopy bluefile & type labels per PPP D119-646-314 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-45A	Bolt	12 Ea (4 ea)	90-Start up Operation	5093618
AN3-47A	Bolt	18 Ea (6 ea)	90-Start up Operation	5084129
AN3-50A	Bolt	18 Ea (6 ea)	90-Start up Operation	5093754x5 509562x13
D3904-1	Washer	18 Ea (6 ea)	90-Start up Operation	5055204
D4506-3	Washer	18 Ea (6 ea)	90-Start up Operation	5111842
D5369-2	Cable Guard	3 Ea (1 ea)	90-Start up Operation	50552234
D5371-2	Hook	3 Ea (1 ea)	90-Start up Operation	5112685
D5372-1	Plug	3 Ea (1 ea)	90-Start up Operation	5090035
D5374-1	Bushing	18 Ea (6 ea)	90-Start up Operation	510039 1x16
D5374-3	Bushing	24 Ea (8 ea)	90-Start up Operation	5094646x16
D5376-1	Drilling Tool	3 Ea (1 ea)	90-Start up Operation	5089850
MS21042L3	Nut	30 Ea (10 ea)	90-Start up Operation	5089340
NAS1149D0332J	Washer	54 Ea (18 ea)	90-Start up Operation	5100407
NAS1149D0316J	Washer	12 Ea (4 ea)	90-Start up Operation	FM134502-2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-45A	12	133	0
	AN3-47A	18	88	0
	AN3-50A	18	67	0
	D3904-1	18	69	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		Part: D119-646-314 Job No: 182344 Serial No/Batch: S112853 Revision: C Inspector: _____ Exp Date: _____ Instructions: FAA STC SR02024SE 15/04/28/216ASTC LoA P-09-0407-RDIMS					
Description Work Order Deviation									
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Conce ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐							
OTHER : _____		Wrong ☐ ensions ☐ tolerance ☐ Part incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							

D4506-3	18	7	0
D5369-2	3	9	0
D5371-2	3	1	0
D5372-1	3	11	0
D5374-1	18	130	0
D5374-3	24	32	0
D5376-1	3	20	0
MS21042L3	30	3,883	0
NAS1149D0316J	12	605	0
NAS1149D0332J	54	2,727	0

Part Specifications

Specifications could not be found.

Plex 8/23/18 7:57 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

10.0 PARTS LIST:

Qty. -313	Qty. -314	PART NUMBER	DESCRIPTION
X		D119-646-313	SKIDTUBE PROTECTOR, LH
	X	D119-646-314	SKIDTUBE PROTECTOR, RH
6	6	D3904-1	WASHER
6	6	D4506-3	WASHER
1		D5369-1	CABLE GUARD, LH
	1	D5369-2	CABLE GUARD, RH
1		D5371-1	HOOK, LH
	1	D5371-2	HOOK, RH
1	1	D5372-1	PLUG
6	6	D5374-1	BUSHING
8	8	D5374-3	BUSHING
1	1	D5376-1	DRILLING JIG
4	4	AN3-45A	BOLT
6	6	AN3-47A	BOLT
6	6	AN3-50A	BOLT
18	18	NAS1149D0332J	WASHER
4	4	NAS1149D0316J	WASHER
10	10	MS21042L3	NUT

11.0 WEIGHT AND BALANCE

The following weight and balance changes are applicable:

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D119-646-313 SKIDTUBE PROTECTOR, LH ON STANDARD SKIDTUBE	4.3 lb 1.95 kg	108.1 in 4.3 m	465 in-lb 8.4 kg-m	-43.4 in 1.7 m	-187 in-lb -3.3 kg-m
D119-646-314 SKIDTUBE PROTECTOR, RH ON STANDARD SKIDTUBE	4.3 lb 1.95 kg	108.1 in 4.30 m	465 in-lb 8.4 kg-m	43.4 in 1.7 m	187 in-lb 3.3 kg-m
D119-646-313 SKIDTUBE PROTECTOR, LH ON FLOAT SKIDTUBE	1.6 lb 0.72 kg	133.3 in 3.38 m	213 in-lb 2.4 kg-m	-43.4 in -1.7 in	69 in-lb 1.2 kg-in
D119-646-314 SKIDTUBE PROTECTOR, RH ON FLOAT SKIDTUBE	1.6 lb 0.72 kg	133.3 in 3.38 m	213 in-lb 2.4 kg-m	43.4 in 1.7 in	69 in-lb 1.2 kg-in



APPROVED

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	VS		
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9734	SHEET 8 OF 15
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SKIDTUBE PROTECTOR KIT	NTS
DATE	17.06.27	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Change Record

PAGE 1 OF 1

Part Number: D119-646-313/-314

Description: SKIDTUBE PROTECTOR, LH/RH

[illegible]